

Work Order ID 64585

Thursday, December 09, 2010 10:14:52 AM

Page 1

Item ID: D206-642-151

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 12/8/2010 Start Qty: 1.00

Required Date: 12/14/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-12-9 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

Work Order ID 64585

Thursday, December 09, 2010 10:14:52 AM



Page 2

Item ID: D206-642-151

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐

M116577

BE 11/05/12

4-Grind weld flush to cap on top surface only.

BE 11/05/12

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time

BE 11/05/12

BB 11/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 3

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

BE 11/05/12

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

8 11/05/13

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, December 09, 2010 10:14:52 AM

Page 4

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Skidtubes	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open crossbolt holes to Ø0.3125"								
	2- Open Air cap hole #6								
	****no wearplate holes for this skidtube****								
	3-Deburr tube and blow out chips from inside the tube								
140  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							
150  QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00							

N/A DP

11-5-17

1 of 11 u/s/12

DP 11-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Thursday, December 09, 2010 10:14:52 AM



Page 5

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								
170		0.00							
	QC6- Inspect dimensions to drawing								
QC	Memo	0.00							
Quality Control									

BE
TW

11-05-19

DD

11-5-19

W/O:		WORK ORDER CHANGES					
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Thursday, December 09, 2010 10:14:52 AM



Page 6

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required								
	2-Bond D2654 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting								
	Start Date: <input type="checkbox"/> 11/05/11 Time: <input type="checkbox"/> 4:06 pm								
	Finish Date: <input type="checkbox"/> 11/05/11 Time: <input type="checkbox"/> 4:23 pm 2:00								
	Pick:								
	Qty <input type="checkbox"/> Part Number <input type="checkbox"/> Description <input type="checkbox"/> Batch								
	A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> 117516 <input type="checkbox"/>								
	Sikaflex expire date: <input type="checkbox"/> 12/01/15								
190	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							



11-05-19

ol 11/05/11

1 ~~8~~ BE 11/05/11

W/O:		WORK ORDER CHANGES					
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Thursday, December 09, 2010 10:14:52 AM



Page 7

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

0.00



Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

BE 11/05/31

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐ m111385/m112860

BE 11/05/31

3-Grind welds flush as per Dwg D3804.

DB 11/06/06

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☐ NONE

11/06/13

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BE 11/06/13

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Thursday, December 09, 2010 10:14:52 AM



Page 8

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D3804

1 0 BE11/06/13

220

0.00



QC5- Inspect visual per QSI004- Fusion Welds

240

QC

Memo

0.00

Quality Control

Sub 1/13

P10 →

230

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Sub 1/13

W/O: 64585

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Person. change					
11/6/13	# 220	change to QC inspection	E. MONTRO		2/A	W	5/11/6/13

Part No: D206-642-151 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Thursday, December 09, 2010 10:14:52 AM

Page 9

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 ϕ 11/06/16

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:30
320 OF
8:001X ϕ M/L 11/06/16

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 ϕ BL 11-6-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 10

Thursday, December 09, 2010 10:14:52 AM

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

1 BR 11-6-16.

280

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive
A/R ☐ Sikaflex-291 ☐ 117516
Sikaflex expire date: ☐ 15/01

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4 ☐

Batch: 117863

1 BR 11-6-16.

W/O:		WORK ORDER CHANGES					
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Thursday, December 09, 2010 10:14:52 AM

Page 11

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290	QC3- Inspect Part Finish	0.00							
									
QC	Memo	0.00							
Quality Control									
300	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									
310	Packaging	0.00							
									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-151								
	Location:								
	PPP Rev:								

PPP Rev: PPP642-151

W/O:		WORK ORDER CHANGES					
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Page 12

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

320

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/11 [Signature]
ME 11-09-11

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, December 09, 2010 10:14:57 AM

Page 1

Work Order ID: 64585

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube







Start Date: 12/8/2010

Required Date: 12/14/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620  Skidtube, 206 Skidtube		Manufactured	No				Each	9.0000	1	1		11/05/12	
<div>Location</div> <div>Loc Qty</div> <div>Loc Code</div>													
<div>LG</div> <div>9</div> <div></div>													
<div>62684</div> <div>9</div> <div></div>													
D3286-1  Doubler		Manufactured	No				Each	23.0000	2	2		BE 11/05/12	
<div>Location</div> <div>Loc Qty</div> <div>Loc Code</div>													
<div>ST050</div> <div>23</div> <div></div>													
<div>52844</div> <div>23</div> <div></div>													
D2647  Cap		Manufactured	No				Each	57.0000	1	1		BE 11/05/12	
<div>Location</div> <div>Loc Qty</div> <div>Loc Code</div>													
<div>FP</div> <div>57</div> <div></div>													
<div>55352</div> <div>57</div> <div></div>													
CR3212-4-04  Cherry Rivet		Purchased	No				Each	425.0000	52	52			
<div>Location</div> <div>Loc Qty</div> <div>Loc Code</div>													
<div>ST311</div> <div>425</div> <div></div>													
<div>112314</div> <div>25</div> <div></div>													
<div>113749</div> <div>200</div> <div></div>													
<div>115698</div> <div>200</div> <div></div>													

116471

(61)

JW 11/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Thursday, December 09, 2010 10:14:57 AM

Page 2

Work Order ID: 64585

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/8/2010

Required Date: 12/14/2010

Start Qty: 1.00

Required Qty: 1.00

D2654-1 Manufactured No



Web

D2649 Manufactured No



Cross Bolt Spacer

B64781

Each 0.0000 1 1



1

DL 11/05/30

Each 53.0000 19 19



19

BE 11/05/31
B 68224 12/19

Location

Loc Qty

Loc Code

Location	Loc Qty
LG	53
58545	2
60652	4
61496	2
62889	13
63359	32

D3286-3 Manufactured No



Spacer

Each 7.0000 2 2



2

BE 11/06/13
B 64564 *2

Location

Loc Qty

Loc Code

Location	Loc Qty
LG	7
46643	7

CCR264SS3-3 Purchased No



Cherry Rivet

Each 330.0000 2 2



2

BE 11/06/13
M 117849 *2

Location

Loc Qty

Loc Code

Location	Loc Qty
ST311	330
112314	4
113539	44
113973	282

Thursday, December 09, 2010 10:14:57 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 10:14:57 AM

Work Order ID: 64585

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/8/2010

Required Date: 12/14/2010

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

Each

1,873.000

2

2



Cherry Rivet



BE 11/06/13

Location

Loc Qty

Loc Code

ST311

1873

110153

35

111359

5

112314

2

114436

448

114450

37

114859

1346

D2680-041

Manufactured

No

Each

20.0000

1

1



Nut Plate



BE 11/06/13

B 700 BB 71

Location

Loc Qty

Loc Code

ST021

20

55366

20

D3805-041

Manufactured

No

Each

0.0000

1

1



Wearplate Assembly Fwd, Low Gear

D3805-045

Manufactured

No

Each

0.0000

1

1



Wearplate Assembly Aft, Low Gear

AN3-37A

Purchased

No

Each

654.0000

7

7



Bolt



1 BL 11-6-16.

1 BL 11-6-16.

7 BL 11-6-16.

Location

Loc Qty

Loc Code

ST353

654

105425

154

111668

500

Thursday, December 09, 2010 10:14:57 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 10:14:57 AM

Page 4

Work Order ID: 64585

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/8/2010

Required Date: 12/14/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D03631 ✓ Purchased

No

Each

8.0000

7

7



Washer

Location

Loc Qty

Loc Code

ST

117291

6

107715

6

ST335

105792

2

2

MS21042L3

Purchased

No

Each

1,213.000

7

7



Nut

Location

Loc Qty

Loc Code

ST300

116549

1213

114784

217

115835

996

D3873-1

Manufactured

No

Each

81.0000

14

14



Bushing

Location

Loc Qty

Loc Code

ST092

68247

70

62197

40

63314

30

ST093

57615

11

11

7 BR 11-6-16.

7 BR 11-6-16.

14, BR 11-6-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 10:14:57 AM

Work Order ID: 64585

Parent Item: D206-642-151

Parent Item Name: Replacement Ski Tube

Start Date: 12/8/2010

Required Date: 12/14/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD416 NAS1149D0463J Purchased No

Each 30.0000 1 1



Washer

Location

Loc Qty

Loc Code

ST300

117460

24

113288

24

ST356

6

115622

6

1 BR 11-6-16

D2651-1 Manufactured No

Each 539.0000 6 6



Plug

Location

Loc Qty

Loc Code

FP

67760.

217

51530

152

62638

65

fpa

322

53349

205

57869

117

6 BR 11-6-16

D2651-3 Manufactured No

Each 432.0000 6 6



O-Ring

Location

Loc Qty

Loc Code

FP

66956

432

46114

12

61962

420

6 BR 11-6-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 10:14:57 AM

Page 6

Work Order ID: 64585

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/8/2010

Required Date: 12/14/2010

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

Each

95.0000

1

1



Screw

Location

Loc Qty

Loc Code

ST292

95

109061

5

115460

90

Each

76.0000

1

1

D2646

Manufactured

No



Aft Cap

Location

Loc Qty

Loc Code

FP-4

17

57332

17

FP6

5

52663

3

63633

2

Return 2010

54

62678

54

Each

1,364.000

2

2

MS27039-1-08

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST291

1364

107378

1

108077

37

110835

455

115108

871

2 BR 11-6-16.

Thursday, December 09, 2010 10:14:57 AM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Thursday, December 09, 2010 10:14:57 AM

Work Order ID: 64585



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 12/8/2010

Required Date: 12/14/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332J Purchased

No

Each

38.0000

2

2



M 117291



2,

BR 11-6-16.

Washer

Location

Loc Qty

Loc Code

ST182

38

104885

38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64585

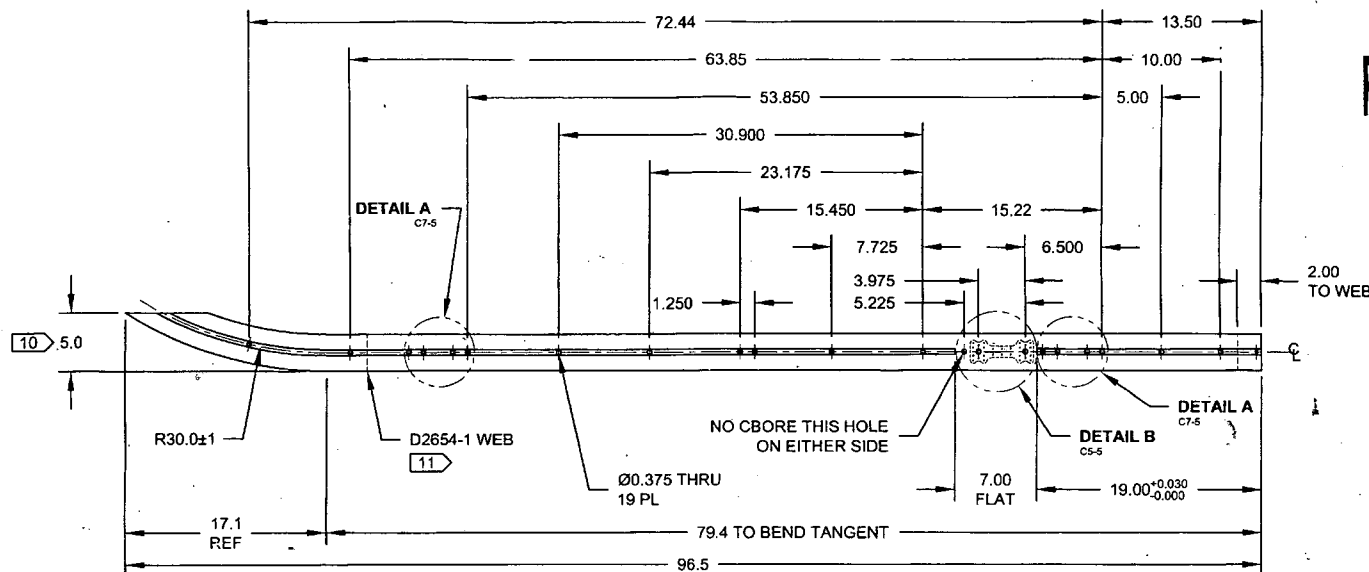
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UP 09.03.03
per ECN 09-538

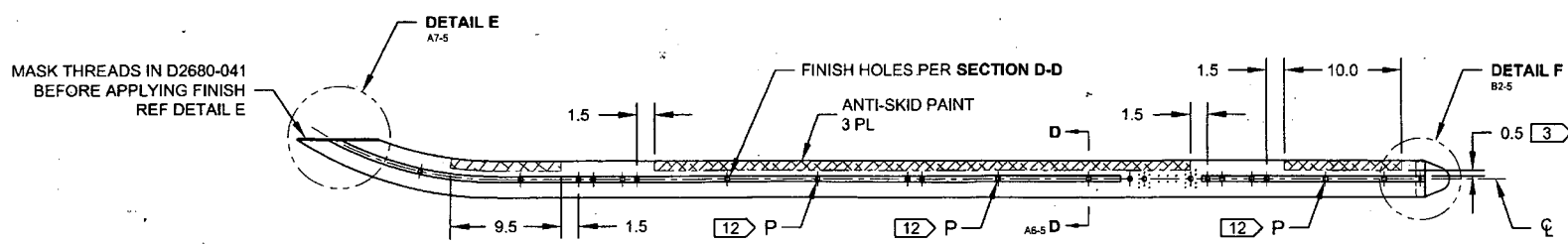
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DRAWN	<i>99</i>	PORT HADLOCK, WA	
CHECKED	<i>99</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>99</i>	D3804	SHEET 1 OF 5
APPROVED	<i>99</i>	TITLE	SCALE
DE APPR.	<i>99</i>	SKIDTUBE ASSEMBLY, 206A/B	NTS
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RELEASE
09.03.03

W064585



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

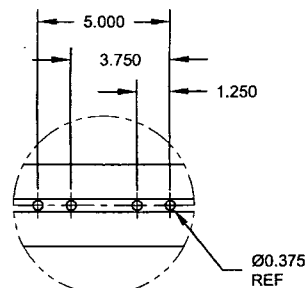
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MFG. APPR.	97	D3804	SHEET 2 OF 5
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W/04586

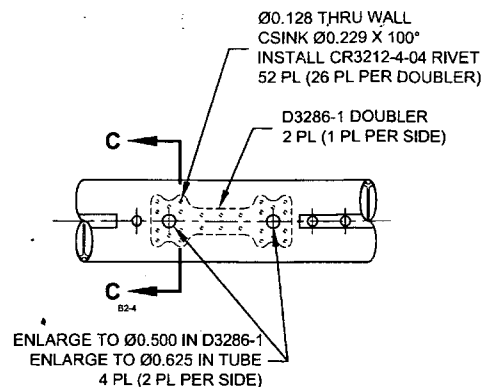


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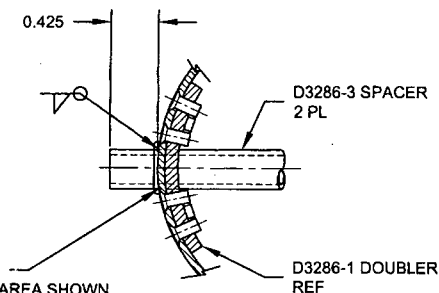
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09.03.03



DETAIL A D6-2
SCALE NONE C2-2
D6-3
C2-3

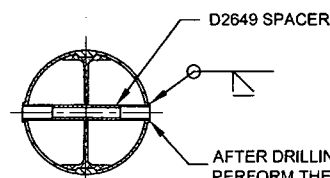


DETAIL B C3-2
SCALE NONE C3-3



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



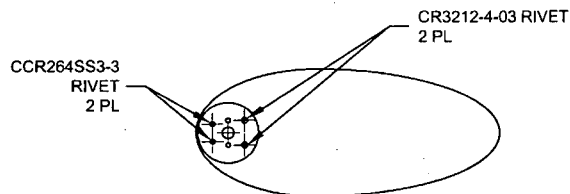
SECTION D-D A4-2
FOR Ø0.375 HOLES ONLY A4-3
SCALE NONE

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

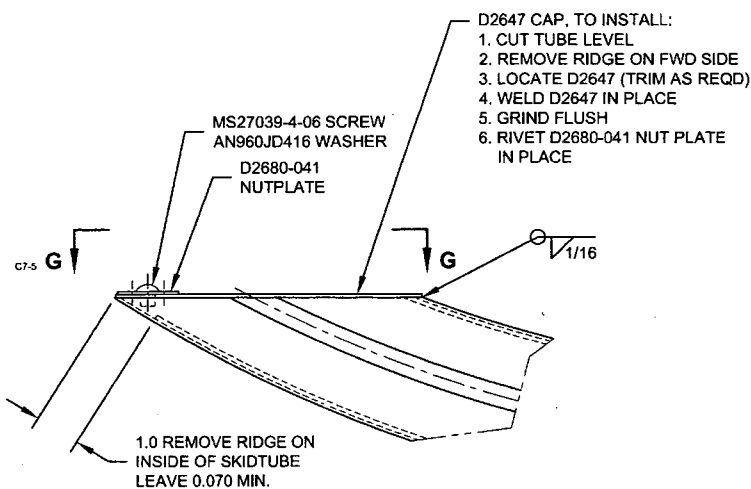
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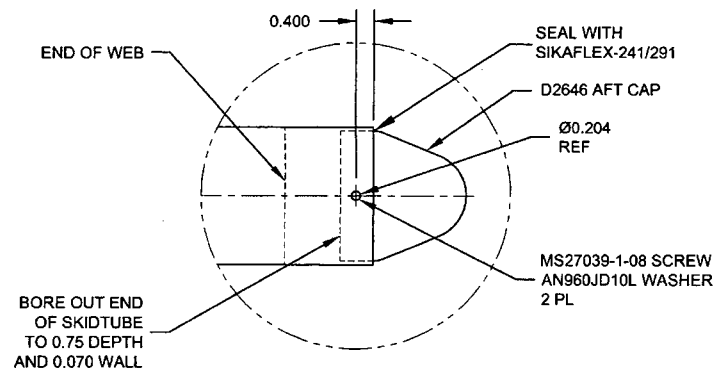
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VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2 B7-3



DETAIL F
SCALE NONE B2-2 B2-3

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NO. 252

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 66358
Part number: S206 642 541
Description: 206
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat Ryan Date of Test Coupon 11-05-09
Welder Barclay Elliott Date of Test Coupon 11-05-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld